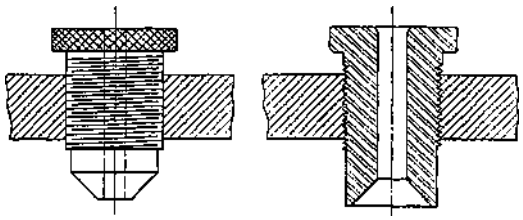
shown in Fig. 8, or by countersinking them, as shown in Fig. 9. In all cases where long guide bushings are used, the hole in the bushing ought to be counterbored or recessed for a certain distance of its length.

Another type of bushing which serves the same purpose as a screw bushing is illustrated in Fig. 10. This bushing, together with the forked lever *D* and clamping bolt and wing-nut shown, will serve not only to locate but also to clamp the work in place. This sliding bushing gives very good results and is preferable to the screw bushing in cases where accurate work is required; but, as a rule, where extreme accuracy would be required, this kind of locating means is not used.

In Fig. 10 the sliding bushing *A* has a close sliding fit in the lining bushing *B.* In the head of the bushing *A* there are two



Figs. 8 and 9. Screw Bushings

screws with hardened heads, which fit into elongated slots in the forked lever or yoke *D,* which, in turn, swivels around pin *E.* The eye-bolt *F* fits into a slot *G* in the yoke, and the wing-nut tightens down the bushing against the work as clearly indicated in the engraving. A comparatively long bearing for th€ bushing is required in order to produce good results. On work that

varies considerably in size, this arrangement works some^ what quicker than does a screw bushing, but it is clearly widen! that it is a rather expensive appliance and that the construction of the jig does not always permit of its application.

In some instances it is necessary to have the screw bushing movable sideways, for instance, when the piece of work to be made is located by some finished surfaces, and a cylindrical part is to be provided with a hole drilled exactly in the center